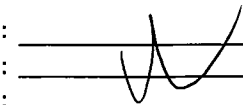
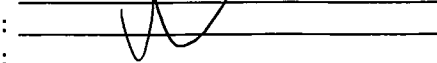


Date: Tuesday, 03/02/2009 3:42:26 PM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D2894-1 REWORK
Job Number	: 45483		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D28941
This Issue	: 03/02/2009 S.O. No. :	Drawing Number	: ECN 08-561
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	:
Previous Run	: 43713	Material	:
Written By	: 	Due Date	: 10/02/2009 Qty: 1 Um: Each
Checked & Approved By	: 		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	HAAS1	HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

PULL FROM STOCK:

1 X D2894-1 B21475

REWORK PER ECN 08-561 &
PER DRWG D2894-1 REV.D

u 09.02.03

J.F. 09/02/07 (1)

2.0	D28941	2.750 Support
-----	--------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 2.750 Support

J.F. 09-02-07 (1)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/02/07 (1)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.F. 09-02-07 (1)

5.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING

REPAINT REWORKED ARE

14:00
400°
14:30

BL 09-02-10 (1)

Date: Tuesday, 03/02/2009 3:42:26 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D2894-1 REWORK

Job Number: 45483

Part Number: D28941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-02-10 (X1)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

RETURN TO STOCK
USING NEW B/N

Matt

88 09/02/11 (X1)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



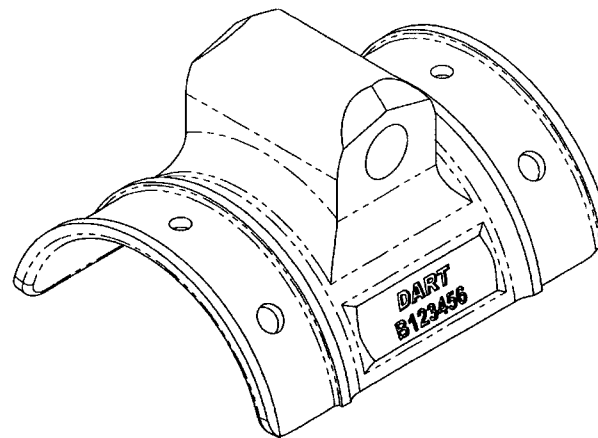
Comment: FINAL INSPECTION/W/O RELEASE

09/02/13 JA

Job Completion




UMF
09-02-13






D2894-1 Ø2.750 SUPPORT

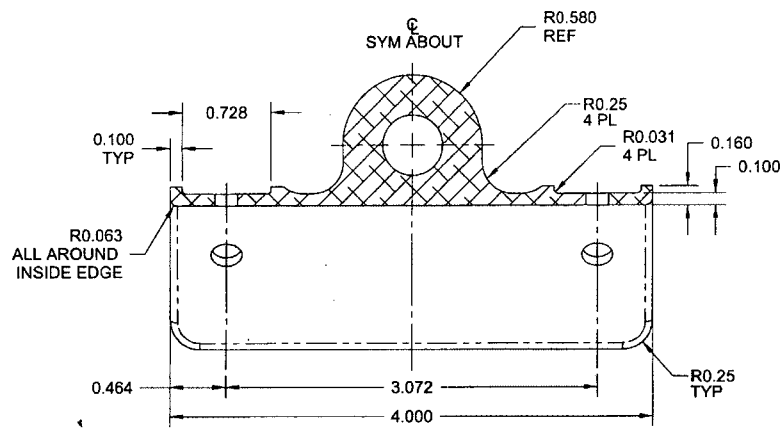
RELEASED
08/11/06

NOTES:

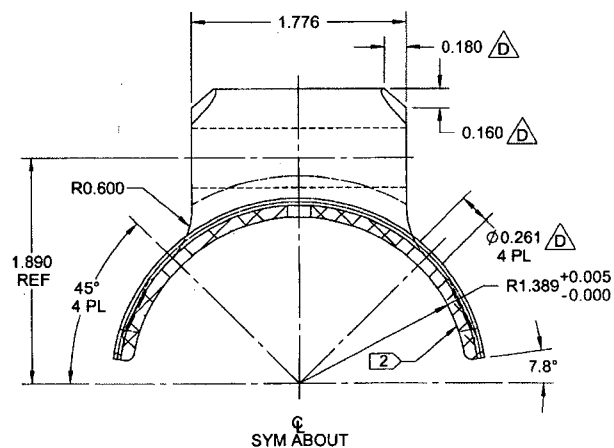
- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR. AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) FINISH: PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2 
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) 0.50" WIDE x 1.56" LONG x 0.005" MIN HEIGHT FLAT,
WITH R0.25 RADIUS OF TRANSITION IN THIS AREA
IDENTIFY WITH DART LOGO AND PART NUMBER ON ONE
SIDE AND DART LOGO AND BATCH NUMBER ON OPPOSITE
SIDE USING 0.010-0.020 DEEP LETTERING
- 7) WEIGHT: 0.98 lbs

Handwritten: m/c 12/8/05

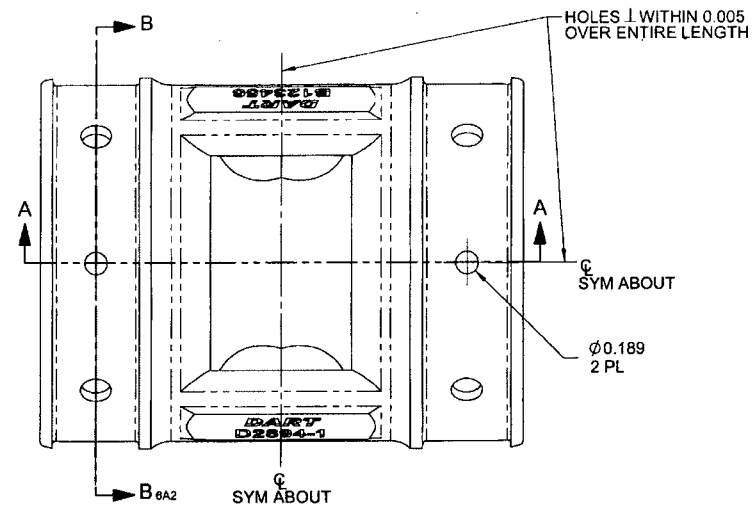
D	DRAWING REFORMATTED. POWDER COAT FINISH REMOVED. CHAMFERS ADDED TO TOP OF PART TO CLEAR ROCKER BEAM. PER BELL TECH BULLETIN 407-08-84. B5-2 0.261 HOLE WAS 0.257. B2-2 REAM FINISH INSTRUCTION ADDED.	AJS	08.11.06
C	ADD MASKING AND PRIME ONLY NOTES, REFORMATTED DRAWING.	DC	07.07.04
B	AS MANUFACTURED	CP	02.07.17
A	NEW ISSUE	CP	02.04.02
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2894	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		Ø2.750 SUPPORT	NTS
DATE	08.11.06	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



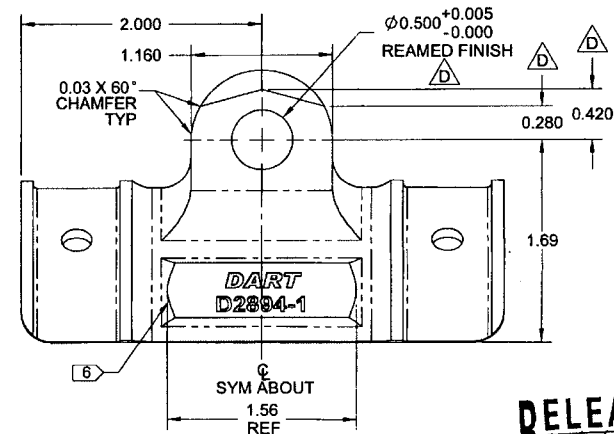
SECTION A-A





SECTION B-B
(VIEW ROTATED 90°)



D2894-1 Ø2.750 SUPPORT



RELEASED
26/11/19 MJP

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2894	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		Ø2.750 SUPPORT	NT
DATE	08.11.06	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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45483